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(71) Applicant (for all designated States except US): **BOREALIS TECHNOLOGY OY** [FI/FI]; P.O. Box 330, FIN-06101 Porvoo (FI).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **GAROFF, Thomas** [FI/FI]; Borgströminkuja 4 K 104, FIN-00840 Helsinki (FI). **JOHANSSON, Solveig** [SE/SE]; Haglingevägen 1, S-444 47 Stenungsund (SE). **WALDVOGEL, Päivi** [FI/FI]; Päiväläispolku 12C, FIN-06450 Porvoo (FI).

(74) Agents: **CAMPBELL, Neil et al.**; Frank B. Dehn & Co., 179 Queen Victoria Street, London EC4V 4EL (GB).

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(54) Title: CATALYST

(57) Abstract: Especially homogeneous supported Ziegler-Natta catalysts may be prepared in a simple one reaction vessel process from a magnesium hydrocarbyloxy starting material which is soluble in a hydrocarbon solvent. The process comprises: (I) reacting a magnesium hydrocarbyloxy compound with a chlorine-containing compound in a non-polar hydrocarbon solvent in which said magnesium hydrocarbyloxy compound is soluble whereby to produce a solution (A); and then either: (II) contacting the solution (A) with a chlorine containing tetravalent titanium compound to produce a solution (B); (III) impregnating solution (B) into a porous particulate support; or (II) impregnating solution (A) into a porous particulate support; and (III) contacting the solid support with a chlorine containing tetravalent titanium compound; or (II) impregnating solution (A) into a porous particulate support pretreated with a chlorine containing tetravalent titanium compound.

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### Catalyst

5           This invention relates to a new process for preparing a Ziegler-Natta catalyst and in particular to a simple solution phase process which can be carried out in one reaction vessel.

10           Ziegler-Natta type polyolefin catalysts have been known since the early 1950's and general methods of their making and subsequent use are well known in the field of polymers.

15           The use of Ziegler-Natta catalysts in multiple step polymerisation of olefins however often results in the production of a polymer containing undesirable inhomogeneities, e.g. gels and white dots.

20           Ziegler-Natta catalysts are generally formed from two components: a compound of a transition metal belonging to groups 4 to 6 of the Periodic Table, often called the procatalyst; and a compound of a metal belonging to groups 1 to 3 of the Periodic Table. Such catalyst compositions have been further developed by depositing the procatalyst on a particulate support and by adding various additives such as electron donating groups.

25           There has been much research into different methods of preparing Ziegler-Natta catalysts and how differing reaction conditions may result in polymer products with differing properties. There remains however, a continuing search for new methods of preparing Ziegler-Natta catalysts with improved properties.

30           One conventional route of preparing Ziegler-Natta catalysts is to use a particulate support throughout the synthesis. For example, in EP-A-688794 a process is disclosed in which a support is contacted with an alkyl metal chloride, the resulting product is contacted with a magnesium compound and the product of this second stage is contacted with a titanium chloride. The reactions in this synthesis obviously take place on the

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surface of or in the neighbourhood of the support. In such a synthesis, the individual reaction steps may proceed differently depending on the nature of the interaction with the support. This may lead to non-uniform active sites and in turn to inhomogeneous polymer material. Recently however, a number of solution phase syntheses of Ziegler-Natta catalysts have been proposed.

In US-A-5817591, a process for producing Ziegler-Natta polymerisation catalysts from magnesium alkoxy chloride is described. The magnesium alkoxy chloride is dissolved in a hydrocarbon solvent with the addition of an alcohol before the solution is contacted with titanium tetrachloride to give a precipitate. This precipitate is converted into the catalyst upon the addition of further titanium tetrachloride and of butyl phthalate.

In EP-A-22376 a catalyst is prepared by suspending magnesium dichloride in hexane and adding ethanol, followed by diethyl aluminium chloride followed by titanium tetrachloride.

Both these methods involve a magnesium compound which is insoluble in hydrocarbon solvents, a further reagent being required to ensure the magnesium compound is solubilised. The inventors of the present invention have surprisingly found that preparing Ziegler-Natta catalysts from a magnesium compound which is essentially soluble in an inert hydrocarbon solvent results in high catalyst activity, the production of homogeneous olefin polymers with low levels of gels and other impurities such as white dots, and the reduction of residual levels of reagents from catalyst production.

In US-A-5589555 a Ziegler-Natta catalyst in solution is prepared by mixing dibutylmagnesium, triethylaluminium, tertiarybutylchloride and titanium tetrachloride in, for example, cyclohexane in one reaction vessel. The resulting catalyst composition is

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then used directly as a Ziegler-Natta catalyst. While this kind of strongly reduced catalyst is suitable for a solution polymerization process operating at a high temperature and a short residence time, it is less  
5 suitable for a suspension polymerization process operating at a relatively low temperature and having a longer residence time. For example the polymerization activity of this type of catalyst tends to decay rapidly with time and the activity at lower polymerization  
10 temperatures is usually low.

It has now been surprisingly found that especially homogeneous supported Ziegler-Natta catalysts may be prepared in a simple one reaction vessel process from a magnesium hydrocarbyloxy starting material which is  
15 soluble in a hydrocarbon solvent. By preparing the Ziegler-Natta catalyst in the solution phase before impregnating the final solution into a support, a much more homogeneous catalyst product is obtained. Clearly, the impregnating solution allows even and homogeneous  
20 impregnation into the support thus enabling production of a catalyst giving a more homogeneous polymer. Moreover, the entire process may take place in a single reaction vessel giving both process and economic advantages over prior art catalysts.

25 Thus, viewed from one aspect the invention provides a process for the preparation of a Ziegler-Natta catalyst comprising the steps of:

(I) reacting a magnesium hydrocarbyloxy compound, with a chlorine-containing compound (e.g. HCl, or more  
30 preferably a chlorine-containing metal alkyl compound, most preferably a chlorine-containing aluminium alkyl compound) in a non-polar hydrocarbon solvent in which said magnesium hydrocarbyloxy compound is soluble whereby to produce a solution (A);

35 (II) contacting the solution (A) with a chlorine containing tetravalent titanium compound to produce a solution (B); and optionally

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(III) impregnating solution (B) into a porous particulate support.

Viewed from another aspect the invention provides a Ziegler-Natta catalyst obtained by the process as  
5 hereinbefore described.

The magnesium hydrocarbyloxy compound used in the preparation of solution (A) is conveniently a magnesium hydrocarbyl hydrocarbyloxy compound, a magnesium dihydrocarbyloxy compound, a magnesium hydrocarbyloxy  
10 chloride compound or a magnesium hydrocarbyl hydrocarbyloxy' chloride compound, i.e. a compound of formula 1



15

where x and y are zero or positive numbers which may or may not be integers, each independently having values of less than 2, y is a positive number having a value of up to 2 and the sum of x, y and z is 2; and each R  
20 independently represents a C<sub>1-20</sub> hydrocarbyl group preferably a C<sub>2-15</sub> group, especially a C<sub>3-10</sub> group and more preferably a C<sub>4-8</sub> group, e.g. an alkyl, aryl, aralkyl or alkaryl group, for example an ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, 2-methyl-hexyl or 2-ethyl-  
25 hexyl group, especially a linear alkyl group. The magnesium hydrocarbyloxy compound may moreover be a magnesium hydrocarbyl alcohol adduct.

The magnesium hydrocarbyloxy compound is used in solution and hence, as will be understood from the  
30 above, may be a mixed compound in which the ratio of Mg to R, to OR or to Cl is a non-integer. In general, for the magnesium hydrocarbyloxy compound to be soluble in the hydrocarbon solvent, where y is large then z or/and x will correspondingly be small. In other words the OR  
35 groups essentially serve to solubilize the compounds. Solubilisation may likewise be enhanced by increased disorder, i.e. by the use of non-identical R groups or

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by the use of R groups of similar structure to the hydrocarbon solvent, for example by the use of aromatic R groups if the solvent is aromatic.

5       Magnesium hydrocarbyloxy compounds usable in the process of the invention may be produced for example by reaction of magnesium dihydrocarbyl (e.g. dialkyl) compounds with alcohols (i.e. hydrocarbyl alcohols), optionally followed by reaction with a chlorinating agent, for example a hydrocarbyl aluminium chloride  
10       (such as for example ethyl aluminium dichloride). The desired values of x, y and z may be achieved by selecting the molar ratios of magnesium dihydrocarbyl compound to alcohol and to chlorinating agent. Likewise magnesium hydrocarbyloxy chlorides in which x is zero  
15       and z is non-zero may be produced by reacting a magnesium dihydrocarbyloxy compound with a chlorinating agent.

      Suitable magnesium dialkyl starting compounds include dibutyl magnesium, butyl-octyl magnesium, and  
20       butyl-ethyl magnesium.

      Suitable magnesium dialkoxy starting compound include magnesium di-(2-ethyl-1-hexanolate), magnesium di-(1-octanolate) and magnesium di-(2-methyl-1-pentanolate).

25       The alcohol used to transform the magnesium dihydrocarbyl starting compounds may be any alcohol capable of forming a magnesium hydrocarbyloxy compound which is soluble in the non-polar hydrocarbon solvent and this may be readily determined by the person skilled  
30       in the art. For example suitable alcohols include those of formula ROH where R is as hereinbefore defined. Preferred alcohols include octanol, hexanol and butanol, but especially 2-ethyl-1-hexanol and 2-methyl-1-pentanol. In general longer chain alcohols, such as C<sub>4-15</sub>  
35       alcohols, are preferred since these are known to form hydrocarbon-soluble adducts with magnesium.

      Where an alcohol is used, it is preferred that the

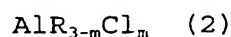
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magnesium dihydrocarbyl compound/alcohol molar ratio is from 1:1 to 1:4, more preferably 1:1.5 to 1:3.5, especially 1:1.8 to 1:3.1.

5 The reaction of the magnesium dihydrocarbyl compound and the alcohol may take place at any temperature but preferably takes place at low temperature, e.g. 0-40°C, especially at room temperature.

10 Where the chlorine containing compound contains metal, the chlorine containing metal compound may be any metal compound which can chlorinate the magnesium compound. Preferably the metal compound is a chlorine-containing group 13 metal compound. More preferably, the compound is a chlorine containing compound of B or  
15 Al, for example BCl<sub>3</sub> or AlCl<sub>3</sub>. Especially, preferably, the compound is a chlorine containing aluminium alkyl compound.

20 The chlorine-containing aluminium alkyl compound should comprise at least an alkyl component and a chlorine component although the ratio of these components may vary. Thus the chlorine-containing aluminium alkyl compound may be of formula (2)



25

wherein R is as hereinbefore defined and  $0 < m < 3$ . Preferred chlorine-containing aluminium alkyl compounds include dimethyl aluminium chloride, diethyl aluminium chloride, diisobutyl aluminium chloride, ethyl aluminium  
30 dichloride (EADC), and methyl aluminium dichloride. Alkyl aluminium dichlorides are preferred and ethyl aluminium dichloride is especially preferred.

35 Instead of the chlorine containing metal compound discussed above, another chlorinating agent may be used. This chlorinating agent may be any compound which can chlorinate the magnesium compound. Specific examples of such compounds are hydrogen chloride, chlorine gas,

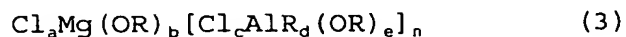
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chlorinated hydrocarbons like tert-butylchloride or methylchloride, sulphur containing chlorine compounds such as  $\text{SOCl}_2$ , and chlorine containing compounds of phosphorus, such as  $\text{PCl}_5$ .

5           The non-polar hydrocarbon solvent employed in step (I) of the process of the invention is one in which the magnesium hydrocarbyloxy compound is soluble. Suitable solvents include  $\text{C}_{5-20}$  hydrocarbons such as cyclohexane, hexane, heptane, octane, methylcyclohexane, especially  
10  $\text{C}_{6-12}$  linear, branched or cyclic hydrocarbons (for example toluene) or mixtures thereof. The hydrocarbon solvent should however be inert in that it does not react with any of the catalyst intermediates or products formed during the preparation of the Ziegler-Natta catalyst.

15           The magnesium hydrocarbyloxy compound and the chlorine-containing compound (preferably the chlorine containing aluminium alkyl) are preferably contacted in Step (I) by adding for example the chlorine-containing aluminium alkyl to a magnesium hydrocarbyloxy compound.  
20 The temperature of the solution is preferably adjusted to between 0 to  $100^\circ\text{C}$ , preferably 10 to  $100^\circ\text{C}$ , especially 20 to  $70^\circ\text{C}$  before the addition of the chlorine-containing aluminium alkyl compound. It is preferred to contact the magnesium compound and the  
25 chlorine-containing compound so that the chlorine-containing compound is added into the magnesium hydrocarbyloxy compound.

Where a hydroxycarbonyl aluminium chloride is used in Step (I), the reaction with the magnesium hydrocarbyloxy  
30 compound results in the formation of a magnesium chloride/aluminium compound which is soluble in the non-polar hydrocarbon and this compound also forms a further aspect of the invention. Thus viewed from another aspect the invention provides a compound of formula (3)





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where  $a+b = 2$  and  $c+d+e = 3$  and  $n$  is 0.6 to 2;  $b$  may be zero or a positive number;  $a$  is a positive number;  $c$  is zero or a positive number;  $d$  and  $e$  are positive numbers; and each  $R$  independently is a hydrocarbyl group as defined earlier), as well as the reaction products thereof with a chlorine containing tetravalent titanium compound, especially titanium tetrachloride.

The magnesium hydrocarbyloxy compound and chlorine containing-aluminium-alkyl compound are preferably used in Step (I) in a Mg:Al molar ratio of 0.5:1 to 1.5:1, more preferably 0.8:1 to 1.2:1, especially about 1:1.

The amount of titanium compound added to the solution (A) is preferably such that the molar ratio of magnesium to titanium is between 5:1 and 1:1, particularly between 3:1 and 1.5:1. This solution (B) will generally be stable for at least one hour, but normally for days.

The titanium compound is preferably a chlorine-containing tetravalent titanium compound such as a trialkoxy titanium monochloride, dialkoxo titanium dichloride, alkoxy titanium trichloride or most preferably titanium tetrachloride. The alkoxy portion may contain 1 to 20, preferably 1 to 10, especially 2 to 8 carbon atoms.

The titanium compound may be added to solution (A) at a temperature from 0 to 90°C, preferably from 10 to 70°C, especially 20 to 60°C, e.g. ambient temperature and is normally administered in a hydrocarbon solvent, preferably the same solvent as used in Step (I).

The solution (B) itself forms a further aspect of the invention and thus viewed from another aspect the invention provides a solution obtainable by the reaction of a solution (A) with a chlorine-containing tetravalent titanium compound.

The solution (B) may be used directly as a polymerisation (e.g. olefin polymerisation) catalyst. However, it is preferably first impregnated into a

porous particulate support. Suitable supports are well-known in the art and include e.g. inorganic or organic carrier materials, preferably solid materials.

Conventional catalyst support materials may be used in this regard, e.g. porous inorganic or organic materials, for example inorganic oxides such as silica, alumina, silica-alumina, silica with titania, zirconia, etc, non-oxides such as magnesium halides, e.g.  $MgCl_2$ , aluminium phosphate, zeolites, etc, celluloses, starches, and polymers such as polystyrene, polymethacrylate, polystyrene-divinylbenzene and polyolefins such as polyethylene and polypropylene.

Carrier materials, especially inorganic materials, are preferably thermically and/or chemically pre-treated, for example so that the water content or the OH group concentration is kept as low as possible. Chemical pre-treatment can for example comprise reaction of the carrier with aluminium alkyl. Inorganic carriers are usually heated to  $100^\circ C$  to  $1000^\circ C$  for 1 to 100 hours before use. The surface area of such inorganic carriers, especially of silica ( $SiO_2$ ) is generally between 10 and  $1000\text{ m}^2/\text{g}$ , preferably between 100 and  $800\text{ m}^2/\text{g}$ . The median weight average particle diameter is generally between 0.1 and 500 micrometers ( $\mu m$ ), preferably between 10 and  $200\text{ }\mu m$ .

The carrier may be treated as described in WO96/00245, WO95/11264, EP-A-619325 or, more preferably, WO95/12622.

Impregnation preferably is effected at 25 to  $50^\circ C$  for 1 to 10 hrs, e.g. 5 hrs. The resulting supported catalyst may be dried by any suitable means, e.g. under a stream of nitrogen at  $50$  to  $100^\circ C$  for 1 to 5 hrs followed by simple heating at the same temperature for a further 12 to 24 hrs.

Impregnation may be carried out so that all the support particles are suspended as a slurry in the solution (B). An alternative and preferred method to

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prepare the catalyst is to add the impregnation solution (B) to the support. Preferably the amount of the impregnation solution (B) is similar to the pore volume of the support material, or slightly higher during the whole impregnation. In this way a highly homogeneous solid catalyst is generated.

The catalyst may be dried using any method known in the art to remove the excess hydrocarbons. Thus, for example, the catalyst may be dried by subjecting it to a vacuum treatment, or by treating the catalyst in a stream of an inert gas, optionally at elevated temperatures. It is preferred to conduct the drying at a temperature below 100°C, to avoid chemical modifications in the catalyst.

The resulting supported catalyst may be employed in the polymerisation of olefins and this forms a further aspect of the invention. Hence, viewed from a further aspect the invention provides a process for the polymerisation of olefins, preferably a two stage process, comprising contacting at least one olefin with a catalyst prepared by a process as hereinbefore described. The catalyst of the present invention gives rise to high olefin polymerisation productivity, especially in a two stage polymerisation process.

The catalyst of the present invention also makes it possible to produce polymer material with good homogeneity. Thus, the products made of such polymer have a low gel level or a low level of phase separation.

The catalyst produced in the process of the invention may be employed in polymerization in a single stage or multi-stage (ie. at least two stage) polymerisation reaction. The reactors used may conveniently be any of the conventionally used polymerization reactors, e.g. reactors for solution polymerization, slurry tank or slurry loop polymerization or gas phase polymerization, etc. The polymer product of an early stage (e.g. the first stage)

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may be passed on to the subsequent stage (e.g. second stage) reactor on a continuous, intermittent or batchwise basis. In an intermittent process, a batch of the reaction mixture is discharged from one reactor and

5 passed to the next reactor at a regular interval which is less than the overall average residence time for the first reactor, e.g. batches may be removed every minute even though the overall residence time is one hour.

Each reactor will conveniently be provided with means

10 for supplying monomer into the reactor and the overall multi-reactor structure will preferably be provided with means for recycling diluents, fluidizing gas or monomer into one or more of the individual reactors. The

polymerisation process may be carried out in a single

15 reactor or using a combination of two or more of the reactor types mentioned above, e.g. a combination of a loop and a gas-phase reactor such as that described in EP-A-517868. Preferably the process of the invention should use only particle forming reactors such as slurry and gas phase reactors or solution phase reactors. The

20 total number of reactors used will depend on the catalyst system used and the molecular weight distribution desired for the polymer end product.

Typically 2 to 5, preferably 2 or 3, most preferably 2

25 main reactors will be used.

For slurry reactors, the reaction temperature will generally be in the range 60 to 110°C (e.g. 85-110°C), the reactor pressure will generally be in the range 5 to 80 bar (e.g. 25-65 bar), and the residence time will

30 generally be in the range 0.3 to 5 hours (e.g. 0.5 to 2 hours). The diluent used will generally be an aliphatic hydrocarbon having a boiling point in the range -70 to +100°C or will be the monomer itself. In such reactors, polymerization may if desired be effected under

35 supercritical conditions, especially in loop reactors.

For gas phase reactors, the reaction temperature used will generally be in the range 60 to 115°C (e.g. 70

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to 110°C), the reactor pressure will generally be in the range 10 to 25 bar, and the residence time will generally be 1 to 8 hours. The gas used will commonly be a non-reactive gas such as nitrogen together with  
5 monomer(s) (e.g. ethylene, propylene, 1-butene, 1-hexene or 1-octene).

For solution phase reactors, the reaction temperature used will generally be in the range 130 to 270°C, the reactor pressure will generally be in the  
10 range 20 to 400 bar and the residence time will generally be in the range 0.1 to 1 hour. The solvent used will commonly be a hydrocarbon with a boiling point in the range 80-200°C.

Optionally, hydrogen may be employed in the  
15 polymerisation process to control the molecular weight of the polymer as is well-known in the art. Thus for example, to produce a low molecular weight polymer may involve use of a relatively high concentration of hydrogen in the polymerization mixture, whereas to  
20 produce a high molecular weight polymer may involve use of no hydrogen or a relatively low concentration of hydrogen.

The catalyst of the invention is suitable for use in the polymerization of olefins, in particular alpha-olefins and mixtures thereof, e.g. C<sub>2-10</sub> α-olefins such as  
25 ethylene, propene, but-1-ene, hex-1-ene, 4-methyl-pent-1-ene, oct-1-ene, etc. The catalyst is particularly effective for the preparation of polyethylene and polypropylene as well as copolymers of ethylene with one  
30 or more copolymerizable monomers, e.g. C<sub>3-20</sub> mono and dienes, styrene, and norbornene, or more preferably C<sub>3-10</sub> α-olefin monomers and copolymers of propene with one or more copolymerizable monomers, e.g. C<sub>4-20</sub> mono and dienes, or more preferably C<sub>4-10</sub> α-olefin monomers or ethylene.

35 The polymers produced using the catalyst of the invention are especially homogeneous having low levels of gels and other inhomogeneities.

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It is possible to prepare the catalyst of the invention by first impregnating the support with a solution (A) before contact with the titanium compound and this forms a further aspect of the invention. Thus, viewed from a yet further aspect the invention provides a process for the preparation of a Ziegler-Natta catalyst comprising the steps of:

(I) reacting a magnesium hydrocarbyloxy compound with a chlorine-containing compound in a non-polar hydrocarbon solvent in which said magnesium hydrocarbyloxy compound is soluble whereby to produce a solution (A);

(II) impregnating solution (A) into a porous particulate support; and

(III) contacting the support with a chlorine-containing tetravalent titanium compound.

Likewise, but less preferably, a solution of the magnesium hydrocarbyloxy compound and chlorine-containing compound may be impregnated into a dry, titanium tetrachloride treated support. Thus viewed from a further aspect the invention provides a process for the preparation of a Ziegler-Natta catalyst comprising the steps of:

(I) contacting a porous particulate support with a chlorine-containing tetravalent titanium compound;

(II) forming a solution of magnesium hydrocarbyloxy compound with a chlorine-containing compound in a non-polar hydrocarbon solvent; and

(III) impregnation said solution into said support.

The invention will now be further described with reference to the following non-limiting Examples and to the accompanying drawings in which:

Figure 1 is an X-ray diffraction pattern of the magnesium/aluminium complex of Example 2.

### Chemicals

The Mg-alkyl ( $\text{MgR}_2$ ) used was BOMAG-A from Schering which was a 20% toluene solution of butyloctylmagnesium  
5 ( $(n\text{-C}_4\text{H}_9)_{1.5}(n\text{-C}_8\text{H}_{17})_{0.5}$  Mg with a magnesium content of 2.92% and a density of 0.8451 g/ml. This reagent was used as such with no preceding purification.

2-ethyl-1-hexanol (EHA) from Merck was used as an alcohol. It was liberated from traces of moisture by  
10 storing it over a molecular sieve.

Ethyl aluminium dichloride (EADC) was obtained from Witco as a 20% pentane solution.

Toluene (Merck) was liberated from traces of moisture by storing it over a molecular sieve.  
15

### Experimental

#### Determination of Ti, Mg, Al and Cl

20 Samples of the catalyst complexes were dissolved in a mixture of nitric and hydrofluoric acid and the metals were measured by flame atomic absorption with a nitrous oxide/acetylene flame. Chloride was determined, after  
dissolution in dilute sulphuric acid, by potentiometric  
25 titration with a standard silver nitrate solution.

#### X-ray diffraction patterns

WAXS patterns were collected in reflection mode  
30 between  $2^\circ$  and  $70^\circ$  ( $2\theta$ ) with a Siemens D500 instrument. The diffractometer was equipped with a Cu anode and a graphite monochromator in the reflected beam. The  $\text{CuK}\alpha$  radiation wavelength was 1.541 Å. The effect used was 40 kV and 35 mA. The sample was loaded in a glovebox  
35 into a Mylar film covered sample holder. The Mylar film forms a half-cylindrical window, allowing X-rays to pass perpendicularly through.

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Ethylene test polymerization was carried out as follows:

1.8 litres of purified n-pentane was introduced into a 3 litre autoclave reactor. The reactor was  
5 heated to 90°C. A 500 ml vessel was pressurized with hydrogen to a pressure of 500 kPa. The supported catalyst component and a predetermined amount of triethyl aluminum (TEA) cocatalyst to reach an Al/Ti molar ratio of 1:15 were introduced into the reactor.  
10 Polymerization was started by feeding ethylene through the vessel so that the partial pressure of ethylene in the reactor was about 1000 kPa. Ethylene was continuously introduced into the reactor to maintain a constant pressure and to replace the amount consumed in  
15 polymerization. The polymerization was allowed to proceed for 1 hour, after which the reaction was terminated by removing the monomer from the reactor. The polymer was then collected, dried and analyzed.

The polymer was weighed, the melt flow rates (MFR<sub>2</sub> and MFR<sub>21</sub>) were determined at 190°C with 2.16 and 21.6 kg loads according to ISO 1133 and bulk density was measured by determining the weight of the polymer powder occupying a specified volume.

#### 25 Example 1

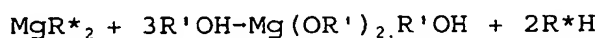
##### PREPARATION OF A MAGNESIUM ALKOXY COMPOUND

20.0 ml (20.291 mmol) of BOMAG-A was introduced into a 150 ml glass reactor under inert conditions at  
30 room temperature. 6.41 ml (40.582 mmol) of 2-ethyl-hexanol was added by syringe into the reactor while stirring. The addition was done in one minute, also at room temperature. The temperature was increased to 60°C, and the reactants were allowed to react with each  
35 other for 30 min. A clear colourless solution with high viscosity resulted.



Example 2**PREPARATION OF A SOLUBLE  $\text{MgCl}_2\text{-Al}(-\text{O}-2\text{C}_2\text{H}_5\text{-C}_6\text{H}_{13})_3$  COMPOUND**

20.0 ml (20.29 mmol) of BOMAG-A was introduced into a  
 5 150 ml glass reactor in inert conditions at room  
 temperature. 9.61 ml (60.87 mmol) of 2-ethyl-hexanol  
 was added by syringe into the reactor while stirring.  
 The addition was done in one minute also at room  
 temperature. The temperature was increased to 60°C, and  
 10 the reactants were allowed to react with each other for  
 30 min. A clear colourless solution with high viscosity  
 resulted. The reaction taking place was as follows:



15

(where  $\text{R}^*$  is  $(\text{n-C}_4\text{H}_9)_{1.5}(\text{n-C}_8\text{H}_{17})_{0.5}$  and  $\text{R}'$  is 2-ethylhexyl)

18.6 ml (20.29 mmol) of ethyl aluminium dichloride and a  
 (EADC) was added at 60°C. The addition took 3 minutes  
 20 and led to a marked decrease in viscosity. The  
 reactants were allowed to react with each other for 30  
 min at this temperature. Precipitation from the  
 solution was prevented by adding toluene until any  
 precipitate disappears. The reaction taking place was:

25



(where  $\text{R}'$  is as defined above)

30 The Mg-complex produced was totally soluble in the  
 toluene-pentane solvent mixture.

The solvents were evaporated at 120°C under a  
 stream of nitrogen resulting in a white powder. The  
 composition of the complex is listed in Table 1 below.

35

Table 1.

	Element	wt%	mol %	mol/mol Mg
	Mg	4.4	0.181	1
5	Al	5.3	0.196	1.1
	Cl	13.9	0.392	2.2
	-O-2C <sub>2</sub> H <sub>5</sub> -C <sub>6</sub> H <sub>13</sub>	61.8	0.475	2.7

## X-ray diffraction

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The X-ray diffraction pattern of the MgCl<sub>2</sub>-Al(-O-2C<sub>2</sub>H<sub>5</sub>-C<sub>6</sub>H<sub>13</sub>)<sub>3</sub> complex is shown in Figure 1 of the accompanying drawings. The pattern shows a peak typical for a larger organic group at 2θ=6° which  
15 corresponds to the -O-2C<sub>2</sub>H<sub>5</sub>-C<sub>6</sub>H<sub>13</sub> group that separates the metals. No sign of crystalline MgCl<sub>2</sub> can be detected in the X-ray spectrum.

Example 3

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**PREPARATION OF A SOLUBLE MgCl<sub>2</sub>:Al(-O-2C<sub>2</sub>H<sub>5</sub>-C<sub>6</sub>H<sub>13</sub>)<sub>3</sub> COMPOUND**

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Into 14.67 kg (17.5 mol) of a solution containing 19.93% by weight BOMAG-A in toluene (supplied by Witco, having a magnesium content of 2.91% by weight) was added  
4.567 kg (35.0 mol) 2-ethyl-1-hexanol (supplied by Neste Oxo) so that the molar ratio of alcohol to Mg was 2:1. The chemicals were allowed to react at about 30°C for 2 hours. 13.22 kg (17.5 moles) of 16.8wt.% solution of ethyl aluminum dichloride in pentane (EADC, supplied by  
30 Witco) was added so that the molar ratio of Al to Mg was 1:1. The chemicals were allowed to react at about 25°C for 3 hours.

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The resulting solution was analyzed and it was found to contain 1.24% by weight Mg and 3.7% by weight Cl.

Example 4

## PREPARATION OF A SUPPORTED CATALYST

4.0 kg ES747JR silica, calcined at 590°C for 5  
5 hours, was loaded into a catalyst mixing tank. 10.4 kg  
of the solution prepared in Example 3 was added into a  
separate reaction vessel. 16.0 kg of toluene was  
further added into the separate reaction vessel. The  
temperature in the separate reaction vessel was adjusted  
10 to 25°C. Finally, 0.531 kg of  $\text{TiCl}_4$  was added. The  
solution in the separate reaction vessel was added over  
5 minutes to the silica in the mixing tank. The mixture  
was stirred for 5 hours at 25-30°C temperature. The  
resulting solid catalyst was dried under nitrogen by  
15 heating the catalyst from 55°C to 88°C for 3 hours and  
keeping the catalyst at 88°C for 18 hours.

The catalyst was analyzed and found to contain 2.4%  
by weight Ti, 2.1% by weight Mg, 13.2% by weight Cl and  
2.4% by weight Al. The bulk density of the catalyst was  
20 360 kg/m<sup>3</sup>.

Ethylene was polymerized using the catalyst in a  
laboratory reactor and the activity was found to be 10.2  
kg PE/g catalyst/h, the bulk density of the polymer was  
370 kg/m<sup>3</sup>, MFR<sub>2</sub> was 0.58 g/10 min and MFR<sub>21</sub> was 20 g/10  
25 min.

Example 5

## PREPARATION OF A SUPPORTED CATALYST

30 To 23.2 grams of the complex prepared according to  
Example 1 was added 23.34 ml of a 16.8% wt. solution of  
EADC in pentane. The chemicals were allowed to react  
and the resulting solution was collected.

A solution was made of 1.15 ml titanium  
35 tetrachloride and 18 ml toluene. To this solution was  
added the solution prepared above. The resulting  
solution was added to 15 grams of ES747JR silica, which

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had previously been calcined at 590°C to remove the hydroxyl groups. The mixture was stirred for 3 hours while temperature increased from 20 to 44°C. The mixture was further stirred for 2.5 hours under nitrogen while the temperature was increased to 74°C. Then the catalyst was dried under nitrogen purge for 3 hours at 74°C. After this, it was further stirred for 7.5 hours while heating to 80°C.

Ethylene was polymerized using the catalyst in a laboratory reactor and the activity was found to be 12.8 kg PE/g catalyst/hr, the bulk density of the polymer was 320 kg/m<sup>3</sup> and MFR<sub>21</sub> was 17 g/10 min.

#### Example 6

##### 15 UNSUPPORTED CATALYST

0.08 ml titanium tetrachloride and 2.94 ml of the complex solution prepared according to Example 3 were mixed in a 15 ml glass flask.

0.8 ml of the solution was injected into a polymerization reactor together with 0.8 ml 10% triethylaluminum solution in toluene. The test polymerization with ethylene was otherwise conducted according to the procedure described above. After 35 minutes polymerization time, the reaction was terminated.

The amount of polymer in the reactor was 440g MFR<sub>2</sub> was 0.41 g/10 min and MFR<sub>21</sub> was 8.8 g/10 min.

#### 30 Example 7

##### PREPARATION OF A SOLUBLE MAGNESIUM:ALUMINIUM COMPOUND

13.8 kg of 19.9 wt-% BOMAG-A in toluene and 8.0 kg 20.1 wt-% BOMAG-A in toluene were mixed in a stirred reactor. Into 21.0 kg of the above BOMAG-A mixture was then added 6.57 kg of 2-ethyl-1-hexanol over 1.3 hours. At the start of the addition the temperature was 13°C,

- 20 -

and it increased during the addition to 42°C. The mixture was allowed to react for 2 hours. The reactor was cooled down to 18°C. Then 19.0 kg of 16.8 wt-% EADC was added over 1.5 hours. The temperature was kept at 20°C. The resulting solution was stirred for another 2 hours.

### Example 8

#### PREPARATION OF SUPPORTED CATALYST

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5 kg ES747JR (calcinated at 590°C for 5 hours) was loaded into a catalyst preparation vessel. An under pressure of -85 kPa was achieved by connecting a vacuum pump to the preparation vessel. 10.1 kg of the solution prepared in Example 7 was added to the preparation vessel over 35 minutes. The temperature was 24-26°C during the addition. The impregnated silica was stirred for 0.5 hours. 6.26 kg pentane was added to the preparation vessel. Finally, 0.664 kg titanium tetrachloride was added to the preparation vessel. The temperature was increased to 53°C, and the impregnated silica was mixed for 3 hours. The resulting catalyst was dried by purging with nitrogen at 85°C.

The resulting catalyst was analyzed and it was found to contain (by weight) 2.4% Ti, 1.9% Mg, 12.4% Cl and 1.9% Al.

The catalyst was test polymerized according to the procedure described above. The activity of the catalyst was found to be 6.2 kg PE/g cat/h, the MFR<sub>2</sub> was 0.39 g/10 min and MFR<sub>21</sub> was 13.5 g/10 min.

Claims:

1. A process for the preparation of a Ziegler-Natta catalyst comprising the steps of:

5 (I) reacting a magnesium hydrocarbyloxy compound with a chlorine-containing compound in a non-polar hydrocarbon solvent in which said magnesium hydrocarbyloxy compound is soluble whereby to produce a solution (A); and then either:

10

(II) contacting the solution (A) with a chlorine containing tetravalent titanium compound to produce a solution (B);

15 (III) impregnating solution (B) into a porous particulate support; or

(II) impregnating solution (A) into a porous particulate support; and

20 (III) contacting the solid support with a chlorine containing tetravalent titanium compound; or

25 (II) impregnating solution (A) into a porous particulate support pretreated with a chlorine containing tetravalent titanium compound.

25

2. A process as claimed in claim 1 wherein said magnesium hydrocarbyloxy compound is a compound of formula 1



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where x and y are zero or positive numbers which may or may not be integers, each independently having values of less than 2, y is a positive number having a value of up to 2 and the sum of x, y and z is 2; and each R  
35 independently represents a C<sub>1-20</sub> hydrocarbyl group.

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3. A process as claimed in claim 2 wherein said magnesium hydrocarbyloxy compound is the reaction product of an alcohol and a magnesium dihydrocarbyl compound.
- 5 4. A process as claimed in claim 3 wherein said magnesium dihydrocarbyl compound is a magnesium dialkyl.
- 10 5. A process as claimed in claim 4 wherein said magnesium dialkyl compound is butyl-octyl magnesium.
- 15 6. A process as claimed in any one of claims 3 to 5 wherein said alcohol is 2-ethyl-hexanol or 2-methyl-pentanol.
7. A process as claimed in any one of claims 1 to 6 wherein said chlorine-containing compound is an aluminium alkyl compound.
- 20 8. A process as claimed in claim 7 wherein said aluminium alkyl compound is ethyl aluminum dichloride.
- 25 9. A process as claimed in any one of claims 1 to 8 wherein said chlorine-containing tetravalent titanium compound is titanium tetrachloride.
10. A process as claimed in any one of claims 1 to 9 wherein said support is silica.
- 30 11. A catalyst obtained by a process as defined in any one of claims 1 to 10.
- 35 12. A process for the polymerisation of olefins comprising contacting at least one olefin with a catalyst prepared by a process as described in any one of claims 1 to 11.

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13. A compound of formula 3



5 where  $a+b = 2$  and  $c+d+e = 3$  and  $n$  is 0.6 to 2;  $b$  may be zero or a positive number;  $a$  is a positive number;  $c$  is zero or a positive number;  $d$  and  $e$  are positive numbers; and each  $R$  independently is a  $\text{C}_{1-20}$  hydrocarbyl group), or  
10 a reaction product thereof with a chlorine containing tetravalent titanium compound.

14. A solution obtainable by the reaction of (i) a solution (A) formed by the reaction of a magnesium hydrocarbyloxy compound with a chlorine-containing  
15 compound in a non-polar hydrocarbon solvent in which said magnesium hydrocarbyloxy compound is soluble with (ii) a chlorine-containing tetravalent titanium compound.

20 15. A process for the polymerisation of olefins comprising contacting at least one olefin with a solution prepared by a process as described in claim 14.



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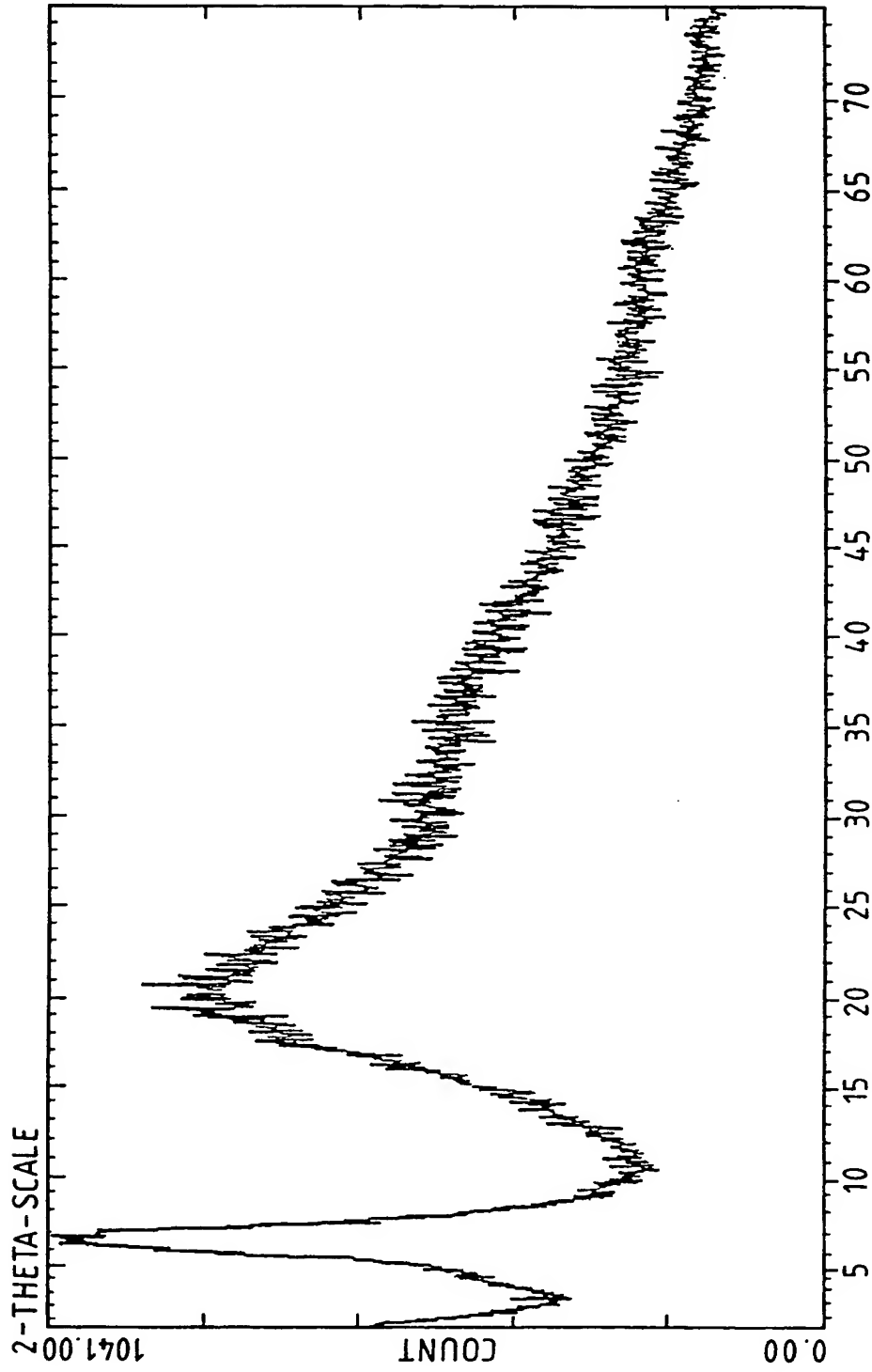


FIG.1.

## INTERNATIONAL SEARCH REPORT

International Application No  
PCT/GB 01/00368

A. CLASSIFICATION OF SUBJECT MATTER  
IPC 7 C08F10/00 C08F4/655

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C08F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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A	WO 91 09881 A (NESTE OY) 11 July 1991 (1991-07-11) example 1	1-15

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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Name and mailing address of the ISA  
European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl.  
Fax: (+31-70) 340-3016

Authorized officer

Parry, J

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